

Work Order ID 84986

ASAP
84986

Page 1

May-31-12 9:12:22 AM

Item ID: D4151-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Fwd Hardpoint Assembly, Upper

Start Date: 30/05/2012 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 11/06/2012 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/05/13 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4151	C								
100		0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per dwg								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: <u>103</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

4X

[Signature]
12/05/13

(4)

[Signature]
12/05/13

[Signature]
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 84986***84986***

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4

Cust Item ID:

Required Date: 11/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/6/12

MF
1205-01

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Picklist Print

May-31-12 9:12:26 AM

Page 1

Work Order ID: 84986

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Parent Item: D4151-043

D4151-043

Parent Item Name: Basket Fwd Hardpoint Assembly, Upper

Start Date: 30/05/2012

Required Date: 11/06/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.07.22 as per revB DD verf:JLM

11.01.21 as per dwg revC DD verf:JLM

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4151-3 *D4151-3* Upper Hardpoint Plate		Manufactured	No			100	Each	18.0000	2	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST103		18							
				82047		2							
				83459		16							
D4151-7 *D4151-7* Fwd Eyebolt Receiver (Upper)		Manufactured	No			100	Each	30.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST103		30							
				82916		30							
AN4C13A *AN4C13A* BOLT		Purchased	No			100	Each	76.0000	2	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST357		76							
				120187		1							
				121556		25							
				121827		50							

CP 12/05/31

CP 12/05/31

CP 12/05/31

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Picklist Print

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Page 2

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Parent Item: D4151-043

D4151-043

Parent Item Name: Basket Fwd Hardpoint Assembly, Upper

Start Date: 30/05/2012

Required Date: 11/06/2012

Start Qty: 4.00

Required Qty: 4.00

MS21043-4

Purchased

No

100

Each

1,307.000

2

8

MS21043-4

**

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1267

119546

147

121162

620

121652

500

NAS1149C0432R

Purchased

No

100

Each

3,970.000

4

16

NAS1149C0432R

**

Washer

Location

Loc Qty

Loc Code

ST297

1114

117291

114

119124

1000

ST298

2856

121255

2856

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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
		X	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
1	2		D4151-1	LOWER HARDPOINT PLATE
2		2	D4151-3	UPPER HARDPOINT PLATE
3	1		D4151-5	FWD BASKET INSTL STUD (LOWER)
4		1	D4151-7	FWD EYEBOLT RECEIVER (UPPER)
5	2	2	AN4C13A	BOLT
6	2	2	MS21043-4	NUT
7	4	4	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 24986 MJS
12/05/31

RELEASED
2011-01-18
MP

D4151-043 BASKET FWD HARDPOINT ASSY (UPPER)

D4151-041 BASKET FWD HARDPOINT ASSY (LOWER)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4151-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D4151-041 = 0.88 lbs
 - D4151-043 = 1.17 lbs

C	AN4 HARDWARE WAS AN3 (B6-1, C3-1 & D3-1); Ø0.252 WAS Ø0.191 (C5-2, D1-2); TIGHTENED TOL ON 1.000 DIM (C5-2, D1-2, C7-3, C3-3); Ø0.250 WAS Ø0.191 (C6-3, B4-3); 1.83 WAS 1.75 (C1-2), 2.84 WAS 2.78 (B3-3) AND 1.88 WAS 1.80 (C1-3) TO PRESERVE 1.SED. REASON: SEE D407-797 DESIGN JOURNAL.	MB	10.12.14
B	ADDED D4151-517 (SHT 3); D4151-5 WAS D3911-1 (ZN B6-1 & D3-1); D4151-7 WAS D3911-3 (ZN C4-1 & D3-1) (ITEMS #5, 6 & 7 REPLACE MS20815-4M20 (ZN C3-1, D3-1 & B8-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C5-2); Ø0.191 2 PL REPLACES Ø0.129 4 PL (ZN D1-2). REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	SC		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.14		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4151 TITLE BASKET FWD HARDPOINT SCALE NTS SHEET 1 OF 3 REV. C COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER CONSTRUCTION THAN ANY OTHER DESIGN WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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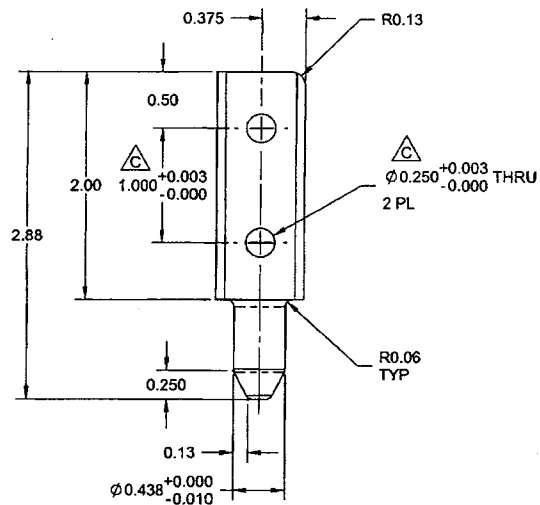
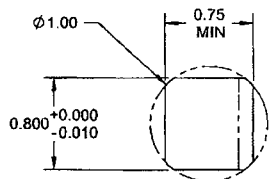
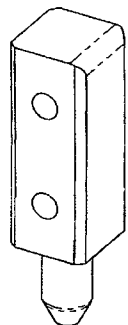
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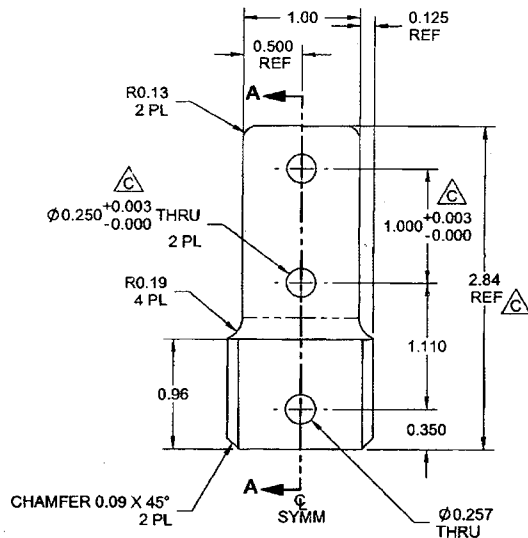
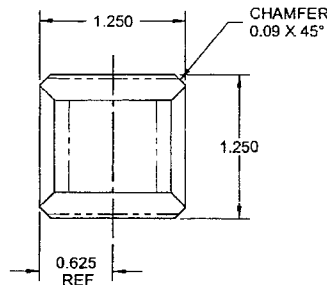
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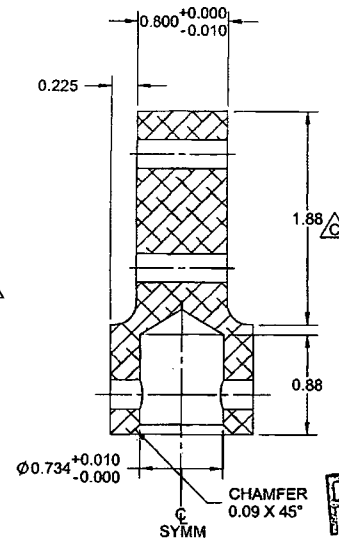
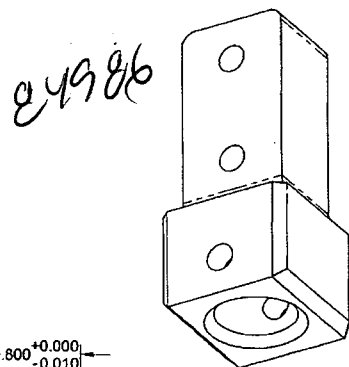
NOTE: Date & initial all entries



D4151-5 FWD BASKET INSTL STUD (LOWER)



D4151-7 FWD EYEBOLT RECEIVER (UPPER)



SECTION A-A

NOTES:

- 1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.36 lbs
-7: 0.70 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<i>JS</i>			
CHECKED	<i>SC</i>		DRAWING NO.	REV. C
MFG. APPR.			D4151	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>		TITLE	SCALE
DE APPR.	<i>[Signature]</i>		BASKET FWD HARDPOINT	NTS
DATE	10.12.14		COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE COPIED FOR ANY PURPOSE OR USED IN CONNECTION WITH ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
R 2011-01-13
RELEASED

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